

Date: Wednesday, 7/4/2007 3:32:43 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UPPER AND LOWER PLATE
 Job Number : 33296
 Estimate Number : 12837
 P.O. Number : N/A Part Number : D35241
 This Issue : 7/4/2007 S.O. No. : NA Drawing Number : D3524 UNDER REV
 Prsht Rev. : NC Project Number : N/A
 First Issue : NA Drawing Revision : N/A
 Previous Run : 32193 Material : N/A
 Written By : J.F. 07.07.11 Due Date : 7/11/2007 Qty: 2 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-04-18 EC
 Est Rev:B Now CNC Machined 07-06-28 JLM

PROTOTYPE

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0375X0.375

3.0

6061-T6 Bar 3/8 x 3"



Comment: Qty.: 0.2365 f(s)/Unit Total: 0.4729 f(s)

6061-T6 Bar .375" X 3"

Batch: M18237

CERTIFICATE OF CONFORMITY
REQUIRED

J.F. 07/07/11

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut Blanks 2.750" Long

J.F. 07/07/11

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA699 Rev: AA & Dwg D3524 Rev: A

2-Deburr per dwg D3443

J.F. 07/07/11 (2)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/07/11 (2)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07.07.11

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 33296

Part Number: D35241

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07.07.19

10.0 QC21 FINAL INSPECTION/W/O RELEASE



07.07.19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



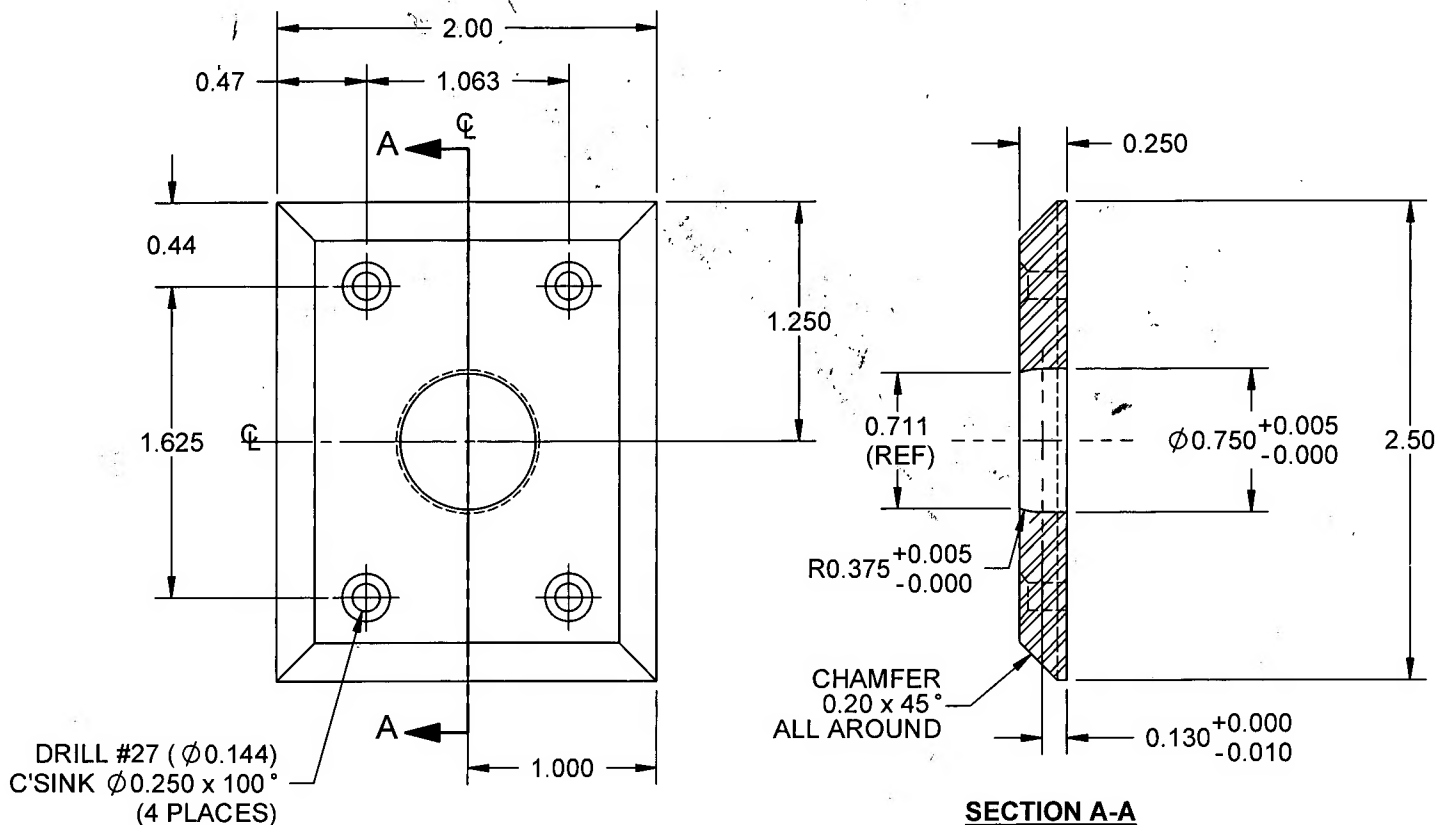
07/07/18

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

07-07-10 CB

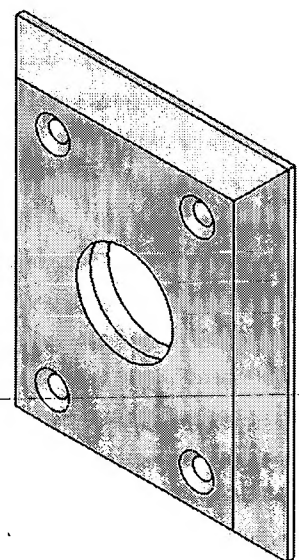
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.06.18	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



D3524-1 LOWER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

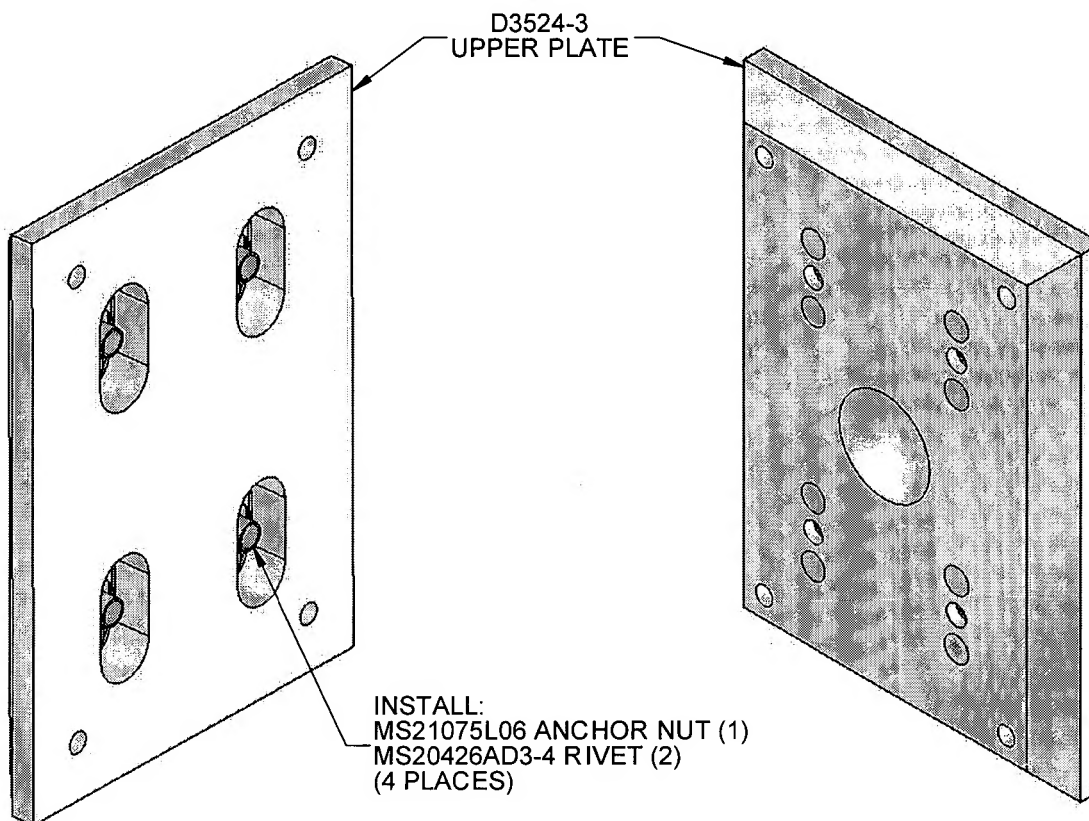


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PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 07.07.10 CB

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.06.18	TITLE UPPER AND LOWER PLATE		SCALE 1:1



D3524-041 UPPER PLATE ASSEMBLY

PARTS LIST:

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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DART AEROSPACE LTD		Work Order: 33296
Description: Lower Plate		Part Number: 03524-1
Inspection Dwg: 3524 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .144"	$\pm .005$ $\pm .001$	Ø .148"				
Ø .750"	$\pm .005$ $\pm .000$	Ø .750"				
2.00"	$\pm .030$	2.000"				
.47"	$\pm .030$.464"				
1.063"	$\pm .010$	1.066"				
.44"	$\pm .030$.438"				
1.250"	$\pm .010$	1.249"				
1.625"	$\pm .010$	1.628"				
C'sink Ø .250"	$\pm .010$	Ø .258"				
1.000"	$\pm .010$	1.000"				
.250"	$\pm .010$.250"				
.711"	$\pm .010$.711"				
R.375"	$\pm .005$ $\pm .000$	R.375"				
20x45°	$\pm .030$	19°x45°				
2.50"	$\pm .030$	2.500"				

Measured by: J.F.	Audited by: SA	Prototype Approval: CB
Date: 07/07/10	Date: 07.07.10	Date: 07.07.11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 05/08/10
Supplier: Copper + Brass

Batch No: M18237
Dart P/O: 2008415

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☐ No ☒ N/A ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☐ No ☒
Q.C. Inspection ☐

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6B0.375X01.000		48	0	0	48	

TSR No. _____

Initials of receiver (if shipment OK) CL

Production/Admin:

Date: 05/08/10
Received/Costing: 2008415
Initial: A

Accounting:

Date: _____
AP/MR: _____
Initial: _____

H:\ISO9000\Forms\Purchase\RECREPORT rev B

SPECIAL INSTRUCTIONS

"Shipping, do not place any packages or goods on top of our material."

FULL		SCRAP		FILLED BY GM		PACKED BY		Q/A AUDIT	
CUSTOMER RECEIVING HOURS				MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT	
BOXES	BARS	CASES	CUSHP	PKGS	SKIDS	BCLS	TUBES	CTNS	FLAT
								1	COILS
INSPECTION		RECORD							

TEST RESULTS

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

ASTM-B221 AMS-QQ-A-200/8

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
181934 00 31.00 LB ALCOA E 0C74914 629545-001

PCS : TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

MARY L. TAYLOR

- General Manager: TORONTO

COPPER AND BRASS SALES CANADA IS A DIVISION OF THYSSENKRUPP MATERIALS, CA. LTD./LIEF

PRINTED 08/04/05 04:29 PM

CONTROL NO 00007

INSPECTION REPORT

MADE IN BRAZIL

N.: 120085402-001

N.: AS4043DI

STANDARD: 1

HIP
TO: COPPER AND BRASS SALES (CA)
6905 KENDERRY GATE UNIT 4
MISSISSAUGA - ONTARIO
CANADA L5T 2Y8

We hereby certify that the material covered by this report has been inspected in accordance with, has been found to meet, the applicable requirements described herein, including any specifications forming accordance with, and part of the description that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per WILKER L. PEREIRA

QUALITY CONTROL.

Item : 07
BC132
Alloy : 6061
Temper : T6511

Item Description
ALUM FLAT BAR
.375 3.000 .000 X 12 FT

CHEMICAL COMPOSITION

CAST	Si	Fe	Cu	Mn	Mg	Ti	Cr	Zn	B	Pb	Bi
19686	0.6300	0.2050	0.2670	0.0310	0.8900	0.0160	0.0440	0.0060	0.0086	0.0004	0.0032

EXTRUDED SHAPES

N. OF TESTS: 3

UTS (KSI)		TYS (KSI)		EL (%)							
Min	Max	Min	Max	Min	Max						
41.79	43.82	37.74	40.17	15.76	16.24						
UTS (KSI)	43.82	43.26	41.79								
TYS (KSI)	40.17	38.12	37.74								
EL (%)	16.24	16	15.76								

OBSERVATIONS

ITEM IDENTIFICATION: 629545-001
ENCOMENDA ALCOA: 14881607 (BC132)
P.O. CONSIG.: C74914